

# Work Order ID 72682

Friday, August 05, 2011 12:39:18 PM



Page 1

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam Assembly

Start Date: 8/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00

Customer:

Reference: rewrok to Rev D

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4271

D

100

0.00



Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:  
1 X D4271-013 B68723  
REMOVE BOTH PLATES  
D4274-3 AND DISCARD/SCRAP  
RETURN TO STOCK:  
D4148-3 B67733  
D4148-5 B67736  
1- Pick and Assemble as per dwg  
D4271 REV D  
D4271-027 B 72643

*EP 11/08/12* *(D)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/12*

*(A)*

**Work Order ID 72682**

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Page 2

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam Assembly

Start Date: 8/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference: rewrok to Rev D

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

RESTOCK USING NEW B/N

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

MP  
11-08-12

# Picklist Print

Friday, August 05, 2011 12:39:16 PM

Page 1

Work Order ID: 72682

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly



Start Date: 8/5/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
11.01.26 RevB dwg EC verified by:DD  
per rev PD1 EC verified by:JLM  
IPP RevB  
IPP RevC 11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3  Stud Receiver, Lower		Manufactured	No				Each	10.0000		-1			
<div> <div>Location</div> <div>ST133</div> <div>69616</div> <div>70856</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>4</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D4148-5  Eyebolt Stud		Manufactured	No				Each	2.0000		-1			
<div> <div>Location</div> <div>ST133</div> <div>69733</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4271-013  Aft Beam Assembly		Manufactured	No				Each	0.0000		1			
D4271-027  End Fitting Assembly Aft Beam		Manufactured	No				Each	0.0000		1			

8/5/11/08/12  
B67733 (10)

8/5/11/08/12  
B67736 (10)

68723 (72682) (10)  
B 72643 (10)

8/5/11/08/12  
8/5/11/08/12

**Work Order ID 68723**

Wednesday, April 20, 2011 10:22:22 AM

Page 1

Item ID: D4271-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00

Required Date: 4/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:     Date: 4-04-20




Tooling:

Date:           

Run Start

QC:           Date:           SPC (Y/N):           Date:           

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	B								
100		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- Pick and Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>196</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

*4/5/11/06/20 (2)*

*5/10/10*

*(+2)*

*11/10/20 4/20*

**Work Order ID 68723**

Wednesday, April 20, 2011 10:22:22 AM

Page 2

Item ID: D4271-013

Accept

Revision ID:

Item Name: Aft Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00

Required Date: 4/25/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/06/21

MF  
11-06-21

# Picklist Print

Wednesday, April 20, 2011 10:22:29 AM

Page 1

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
11.01.26 RevB dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C13A  BOLT		Purchased	No				Each	35.0000		4		4/21/06/20	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST353				35					
				117366				35					
MS21043-4  Nut		Purchased	No				Each	1,180.000		4		4/21/06/20	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				40					
				104603				40					
				ST300				600					
				117423				600					
				ST301				540					
				114523				3					
				116188				237					
				116549				300					
NAS1149C0432R  Washer		Purchased	No				Each	6,492.000		8		4/21/06/20	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST297				6492					
				116900				1492					
				117291				5000					

M117793 (X)

4

4

8

8

# Picklist Print

Wednesday, April 20, 2011 10:22:29 AM

Page 2

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

D4148-3

Manufactured No

100

Each

5.0000

1



Stud Receiver, Lower

Location

Loc Qty

Loc Code

ST132

5

67733

5

D4148-5

Manufactured No

100

Each

12.0000

1



Eyebolt Stud

Location

Loc Qty

Loc Code

ST133

12

67736

12

D4274-3

Manufactured No

100

Each

6.0000

2



Plate, Aft Support

Location

Loc Qty

Loc Code

ST139B

6

68162

6

D4276-1

Manufactured No

100

Each

3.0000

1



Aft Beam

Location

Loc Qty

Loc Code

st200

3

65885

3

AN3C12A

Purchased No

100

Each

51.0000

6



Bolts

Location

Loc Qty

Loc Code

ST351

51

116924

6

117313

45

Wednesday, April 20, 2011 10:22:30 AM

Shop Packet Print

Page 2

*Handwritten notes:*

- EP 11/06/20* (multiple instances)
- Rem to stock 72682*
- Refer to stock 72682*
- See P on 72682*
- M117514 (6x)*
- M117794 (6x)*
- LOG-A*

# Picklist Print

Wednesday, April 20, 2011 10:22:30 AM

Page 3

Work Order ID: 68723

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18 Purchased No  
Rivet



100 Each 346.0000 8



16  
4/24/06/20  
1114808 (160)

Location Loc Qty Loc Code

ST323 346

117411 346

MS21043-3 Purchased No  
Nut



100 Each 948.0000 6



12  
4/24/06/20

Location Loc Qty Loc Code

FG 80

103691 80

FP-B -5

112314 -5

ST301 873

112314 873

NAS1149C0332R Purchased No  
Washer



100 Each 5,261.000 12



12  
24  
4/24/06/20

Location Loc Qty Loc Code

ST297 5261

116304 55

117291 4606

117460 600

24

Wednesday, April 20, 2011 10:22:30 AM

Shop Packet Print

Page 3

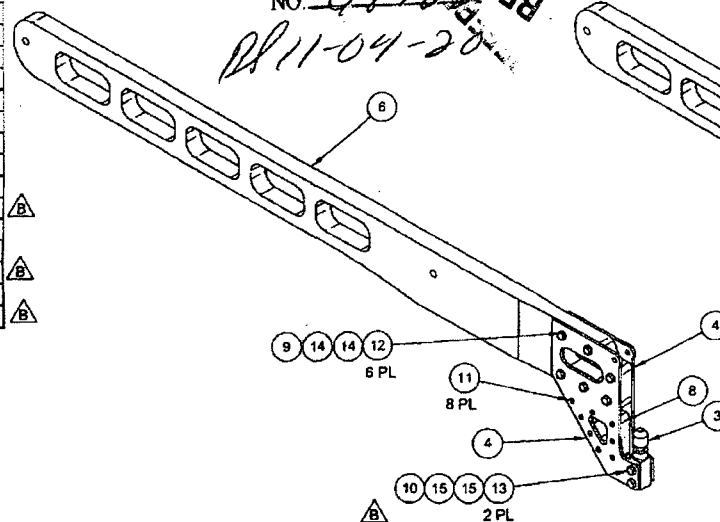


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

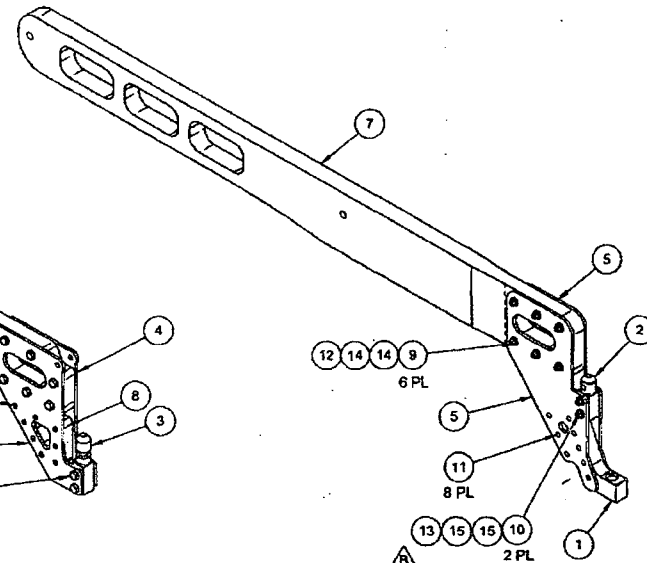
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48722

REF ID: A11-04-20

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED  
2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D4271**  
REV. B  
SHEET 1 OF 2  
TITLE  
SUPPORT BEAM ASSEMBLIES NTS

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